



pivoted at  
V, and  
slotted at  
the other  
end where  
it is locked  
by an

application of the screw and washer *T* and *S*, a steel stud *U* acting as a support for this end. The four legs of the jig *W* are made of hardened steel, screwed into the plate and protruding through the other side to act as a rest when placing the work in position. It will be noted in the construction of this jig that all parts are easily replace

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that al-  
though  
the jig  
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somewh  
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cost,  
the  
provisio  
n for  
upkeep  
is ex-  
cellent.  
It is  
obvious  
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drilling  
is done  
*against*  
the  
clamps,  
so that  
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holding  
the  
work.

Fig. 2. Jig with Interchangeable Bushings for Different Tools used in Machining Cylindrical Part *A*      Drilling and Reaming

Jig. — The casting *A*, shown in Fig. 2, is part of an electrical machine, and has been previously turned and faced. It is required for this operation that the work be located by the previously turned and faced surfaces. The jig body in this instance is made of cast iron and is of box section, as shown at *S*; it is bored out to receive the two hardened and ground locating rings *E* and *F*. There are three pins *C* located 120 degrees apart, which act as stops for the end of the casting, the ends of the pins being